

Date: Monday, 07/04/2008 11:47:23 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SHIM
 Job Number : 38435
 Estimate Number : 13188
 P.O. Number :
 This Issue : 07/04/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D37511
 First Issue : / / Type : SMALL / MED FAB Drawing Number : D3751 REVB
 Previous Run : 38074 Project Number : N/A
 Material : B
 Due Date : 18/04/2008 Qty: 20 Um: Each
 Written By :
 Checked & Approved By : JD 08-4-06
 Comment : Est Rev:A 08-01-30 new issue DD verified by:
 Est Rev:B 08-03-18 chg to revB DD verified by:

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 0.0311 sf(s)/Unit Total : 0.6216 sf(s)
 6061t6 sheet .080" thick
 (M6061t6s080)
 Batch: 106370 B 8-4-8

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3751
 Dwg Rev: B B 8-4-8
 Prog Rev: B

(35)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Codullo (35) count

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr if necessary

B 08/04/09 (35)

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Part Number: D37511

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/09 +35

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

M-L 08/04/09

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-L 08/04/09

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 08/04/09 (35)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 117

8/4/9

(35x)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



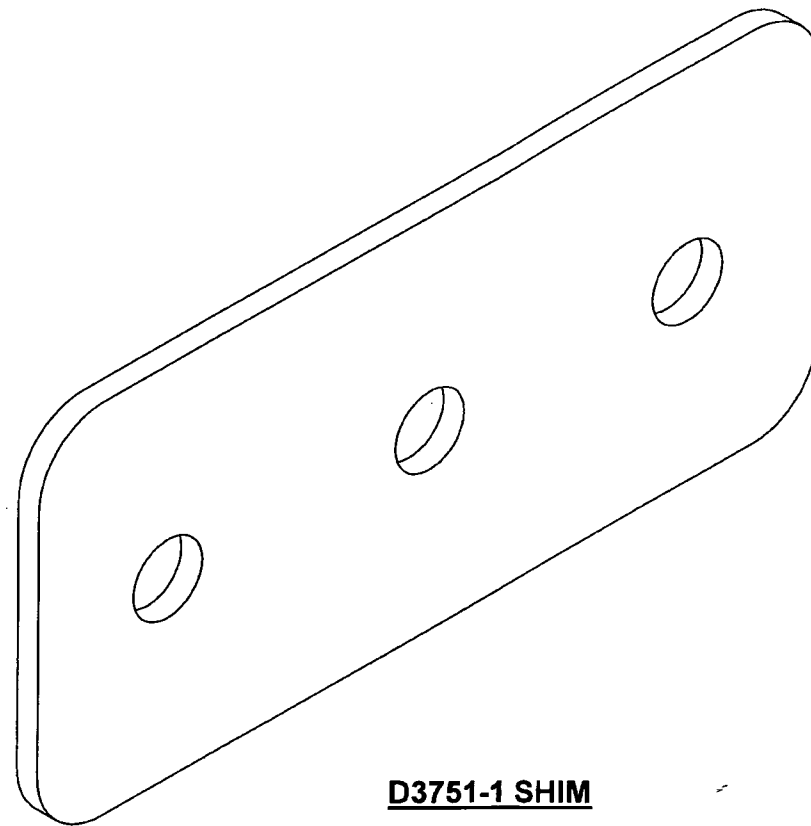
Comment: FINAL INSPECTION/W/O RELEASE

08/04/10

Job Completion



08-04-10



D3751-1 SHIM

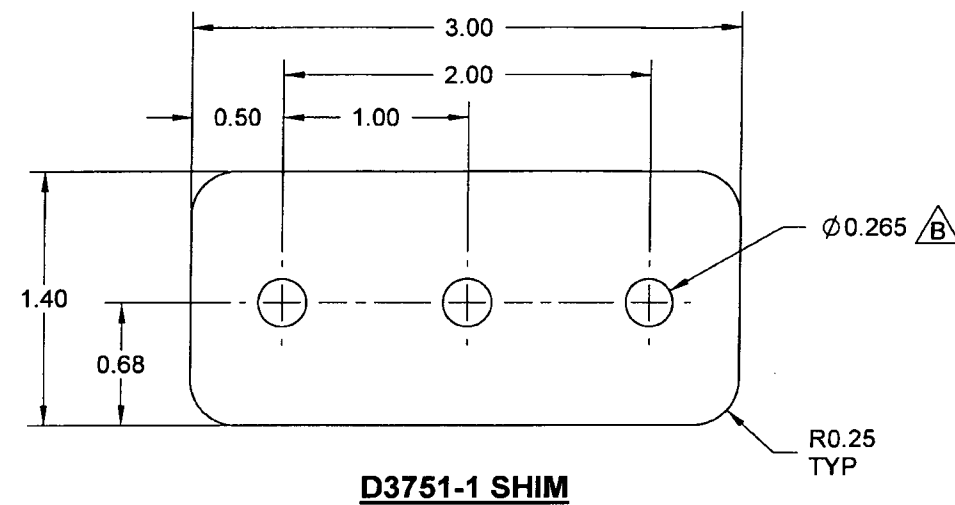
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WITHOUT NOTICE
WORK ORDER
NO. 38435

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY D3751-1 WITH DART P/N D3751-1 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs



B	-3 SHIM DELETED. MATERIAL WAS 0.060 THICK. SHEET 2 ZONE C4 Ø0.265 HOLE WAS Ø0.193.		AJS	08.02.26
A	NEW ISSUE		AJS	08.02.11
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD		
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA		
CHECKED	LE	DRAWING NO.	REV. B	
MFG. APPR.	MP	D3751	SHEET 1 OF 2	
APPROVED	MP	TITLE	SCALE	
DE APPR.	MP	SHIM	NTS	
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DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	ASB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	MP	D3751	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	SHIM	NTS
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